Date:

Thursday, 3/9/2006 7:56:24 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 26150

Estimate Number

: 11005

P.O. Number

This Issue

: NIA

: 3/9/2006

S.O. No. : N IA

: NC

: 26150

: 3/8/2006

: SMALL /MED FAB Type

Drawing Name

Part Number

: D412704041

Drawing Number

: IIN-D412-704 PG6,11

: PEDAL ASSEMBLY

: N/A Project Number **Drawing Revision**

Material

: 3/15/2006 **Due Date**

Qty:

4 Um:

Each

Previous Run Written By

Comment

Prsht Rev.

First Issue

Checked & Approved By

Removed hardware on Step 2; Added : Est Rev:B

Figures 1-3 KJ/RF

Est Rev:C 06.03.08

Re-format

EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

SMALL FAB 1 1.0

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg IIN-D412-704 and Figures 1-3

Note: Only engage one thread on each bolt.

2.0

D3204041

Pedal Assembly



Comment: Qty.:

1.0000 Each(s)/Unit

Total:

4.0000 Each(s)

Pick:

Qty

Part number

Description

batch

1

D3204-041

Pedal Assembly

3524

3.0

D32051



1.0000 Each(s)/Unit

Total:

4.0000 Each(s)



Comment: Qty.:

Pick:

Qty

Part number D3205-1

Description

B25964

4.0

D32053

Bracket

Comment: Qty.:

1.0000 Each(s)/Unit

Total:

4.0000 Each(s)

Pick:

Qty

Part number

Description

Baleool V

 X^{1}

D3205-3

GHW Bracket

	Dart	Aeros	pace	Ltd
--	-------------	--------------	------	-----

W/O:		WORK ORDER (CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date C		Approval Chief Eng / Prod Mgr	Approval QC Inspector
`							
					+		
Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	
			QA:	N/C Close	d:	Date:	

NCR:		·	VORK OR	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B	Verification	Annaval	Ammerical	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
			-	·				
							-	

Thursday, 3/9/2006 7:56:24 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: PEDAL ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 26150 Part Number: D412704041 Job Number: Description: Seq. #: Machine Or Operation: Pedal Arm 5.0 D32061 Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Bables V Description Qty Part number 1 D3206-1 Pedal arm 6.0 D3209041 Bracket 4.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total: Pick: 1 x B23194/3xB23527 V Description Qty Part number D3209-.041 Bracket Bolt 7.0 AN310A Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: batch Description Qty Part number AN3-10A Bolt 8.0 AN3154R 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Comment: Qty.: Pick: batch Description Qty Part number m17566 1 AN315-4R Nut AN410A Bolt 9.0 Comment: Qty.:

4.0000 Each(s)

batch

<u>M18057</u>

.

Pick:

Qty

1

1.0000 Each(s)/Unit Total:

Part number

AN4-10A

Description

Bolt

W/O:			WORK ORDER	CHANGES				
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:	:	PAR #:	Fault Category:	NCR: Ye	es No DG	QΑ:	Date:	
				QA	: N/C Close	ed:	_ Date: _	

NCR:			WORK ORE	DER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B	· · · · · · · · · · · · · · · · · · ·	Verification	Approval Chief Eng	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector
		•						
					;			
				,				
					·			

Thursday, 3/9/2006 7:56:24 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: PEDAL ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Part Number: D412704041 Job Number: 26150 Job Number: Description: Seq. #: **Machine Or Operation:** Bolt 10.0 AN412A Comment: Qty.: Total: 8.0000 Each(s) 2.0000 Each(s)/Unit Pick: Part number Description batch Qty M18822 V 2 Bolt AN4-12A 11.0 AN413A Bolt 4.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total: Pick: Description batch Qty Part number AN4-13A Bolt 12.0 AN960JD10 20.0000 Each(s) Comment: Qty.: 5.0000 Each(s)/Unit Total: Pick: batch Description Qty Part number m195211 5 AN960JD10 Washer AN960JD416 Washer 13.0 Comment: Qty.: 11.0000 Each(s)/Unit Total: 44.0000 Each(s) Pick: Description Qty Part number <u>m190</u>85 V 11 AN960JD416 Washer

AN960JD416L

14.0

Washer

Comment: Qty.:

Pick:

Qty

3

3.0000 Each(s)/Unit

Total:

batch

12.0000 Each(s)

Part number AN960JD416L

Description Washer

11100229 V

Dart	Aer	osna	ce	l td
Dail	761	vova	CC	Lu

		- 				`\				
W/O:			WO	RK ORDER CH	IANGES		·····			
DATE	STEP	PRO	OCEDURE CHAI	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
• • • • • • • • • • • • • • • • • • • •										
			V 100 100 100 100 100 100 100 100 100 10							
		·								
Part No		PAR #:	Fault Çateg	jory:	NC	R: Yes	No DQ	A:	Date:	
						QA: N	C Close	d:	_ Date: _	
NCR:		1	NORK ORDE	R NON-CONF	ORMANCE	(NCR	(1)			
DATE	OTED	Description of NC	<u> </u>	Corrective Action	Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descri	ption	Sign & Date	Secti		Chief Eng	QC Inspector
									,	
				:					,	
		·								

Thursday, 3/9/2006 7:56:24 AM Date: User: Kim Johnston **Process Sheet Drawing Name: PEDAL ASSEMBLY** Customer: CU-DAR001 Dart Helicopters Services Part Number: D412704041 Job Number: 26150 Job Number: Seq. #: Description: **Machine Or Operation:** Nut MS21042L3 15.0 Total: 12.0000 Each(s) Comment: Qty.: 3.0000 Each(s)/Unit Pick: Description Qty Part number MS21042L3 Nut 16.0 MS21042L4 20.0000 Each(s) 5.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Qtv Part number Description 5 MS21042L4 Nut 17.0 MS24694S102 Screw 4.0000 Each(s) Comment: Qty.: Total: 1.0000 Each(s)/Unit Pick: batch <u>M14604</u> V Description Qty Part number MS24694S102 Screw Bolt 18.0 MS951910 Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: 1<u>XB15159</u>/3XM100290 V Qty Part number Description 1 MS9519-10

AN960JD10L 19.0

Washer

16.0000 Each(s)

4.0000 Each(s)/Unit Total:

Comment: Qty.: Pick:

Qty

Part number AN960JD10L

Description Washer

m18235 V



Dart	Ae	ros	pac	e L	td
- u, t	\sim		~~~		

W/O:			\A/C	DK ODDED CHANG	250				
WV/U:			AAC	ORK ORDER CHANG	3E9			T 2	1
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
									:
							-		
:									
Part No):	PAR #:	Fault Cated	iorv:	NCR: Yesz	OQ (6/V	A: 2	Date: &	Way 1/3
		PAR #:		, o., j.	QA: N	I/C Close	d:	Date:	<u>-1948</u>
NCR:				R NON-CONFORM					
NCK.	T				·	- /			I
DATE	STEP	Description of NC Section A	Initial	Corrective Action Sec Action Description	ction B Sign 8		cation on C	Approval Chief Eng	Approval QC Inspector
		Occilorry	Chief Eng	Chief Eng	Date			- Office Ling	QO Mapeciol

Thursday, 3/9/2006 7:56:25 AM Date: Kim Johnston **Process Sheet** User: Drawing Name: PEDAL ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 26150 Part Number: D412704041 Job Number: Description: Seq. #: Machine Or Operation: Bolt 20.0 AN36A 8.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Pick: Part number Description AN3-6A Bolt 21.0 QC4 100% KITS FOR COMPLETENESS PACKAGING RESOURCE #1 PACKAGING 1 22.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_ DOCUMENT CONTROL 23.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

Dart Ae	rospace	Ltd							
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							-		
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	_ Date: _	
					QA: N	I/C Close	d:	_ Date: _	
NCR:		\	VORK ORE	ER NON-CONFORM	ANCE (NCF	₹)			
DATE	0.750	Description of NC		Corrective Action Sect		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
							•		:

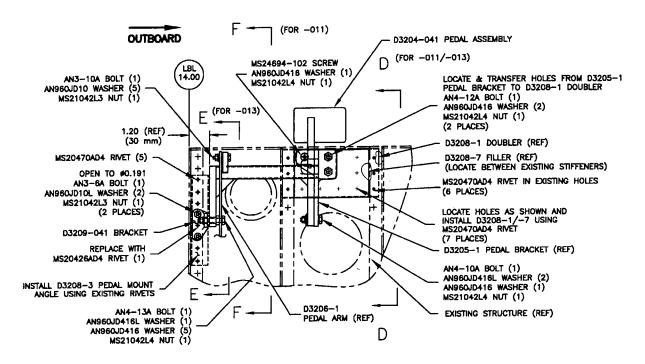


Figure 2 - Detail A. View looking AFT (Co-pilot's Side -011/-013 Installations).

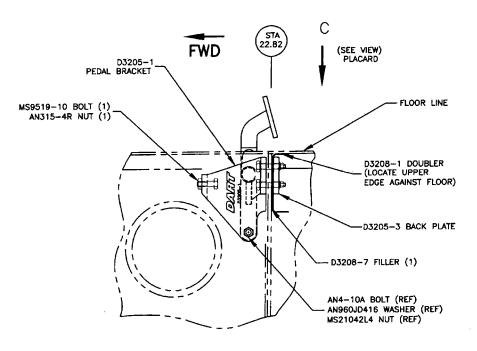


Figure 3 - View D-D. View looking Inboard (-011/-013 Installations)

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 36150

• COPYRIGHT © 2004 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: A

Date: 04.02.03

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Qty -043	Qty -045		
-011	-013	-041	-045	-043	Part Number	Description
X					D412-704-011	COPILOT'S EMERGENCY CARGO RELEASE KIT (BELL 212/ 214 / 412)
	Х				D205-704-013	COPILOT'S EMERGENCY CARGO RELEASE KIT (BELL 205)
1	1	X			D412-704-041	PEDAL ASSEMBLY (205/ 212/ 214/ 412)
	1	 ^ -	Х		D205-704-043	CABLE ASSEMBLY (205)
1	<u> </u>			X	D412-704-045	CABLE ASSEMBLY (212/ 214/ 412)
<u> </u>				-^ -	D412-704-043	OADEL ACCEMBET (212/214/412)
		1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
		1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
		1	-		D3205-3	BACK PLATE (OR ECM 999709-5)
-		1			D3206-1	PEDAL ARM (OR ECM 999704-1)
	1	· · · · · ·			D3207-1	BRACKET
1	<u> </u>				D3207-2	BRACKET
•	1				D3207-3	BRACKET
1	•				D3207-5	BRACKET
1	1	-			D3208-1	DOUBLER (OR ECM 999709-1)
-i	· · · · · ·				D3208-11	FILLER
1	1				D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1				D3208-5	MOUNT ANGLE
1	1		-		D3208-7	FILLER (OR ECM 999709-3)
1					D3208-9	DOUBLER
		1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1				D3214-1	PLACARD (OR ECM 999712-1)
•			1		D3217-1	CABLE
				1	D3217-3	CABLE
			1	1	D3257-1	FITTING
			1	1	D3258-1	ANGLE BRACKET
		1			AN315-4R	NUT
		5	2	2	AN960JD10	WASHER
		4	2	2	AN960JD10L	WASHER
		11			AN960JD416	WASHER
		3			AN960JD416L	WASHER
			3	3	NAS509-3	NUT
	-	3	2	2	MS21042L3	NUT (OR MS21042-3)
		5			MS21042L4	NUT (OR MS21042-4)
4	4				MS21919DG5	CLAMP
		1			MS24694-S102	SCREW
	2				MS35489-10	GROMMET
			1	1	AN3-5A	BOLT SHOP COPY
		2			AN3-6A	BOLT
		1			AN3-10A	BOLT
			1	1	AN3-13A	BOLI
		1			MS9519-10	BOLT UNCONTROLLED
		1			AN4-10A	BOLT GURLECT TO AMILINE
		2			AN4-12A	BOLT WITHOUT NOT
		1			AN4-13A	BOLT WORK ORDE
ŀ						1 2015

• COPYRIGHT © 2004 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: A

Date: 04.02.03